










Date: Tuesday, 07/04/2009 10:17:14 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP STRUT
Job Number : 46947	
Estimate Number : 11945	
P.O. Number :	Part Number : D2017131
This Issue : 07/04/2009 S.O. No. :	Drawing Number : D2017 REV <i>F</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : <i>F</i> <i>R</i>
Previous Run : 34983	Material :
Written By :	Due Date : 22/04/2009 Qty: 4 Um: Each
Checked & Approved By : <i>JUD 09.04.07</i>	
Comment : Est F 02.06.19 Update processes (Ref. ECN 435) KJ	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304TR0750W049 304 RD Tube .750 x .049W
	 
Comment: Qty.: 2.7738 f(s)/Unit Total: 11.0951 f(s) Punch tube type 304-2B, 3/4" Ø. X .049" wall to length per Dwg. D2017 & spec control D2638 <i>SD 09/04/27</i> (4) Batch No. <i>M111331</i> Deburr <i>M-A 09/04/28 (4X)</i>	
2.0	QC5 INSPECT WORK TO CURRENT STEP
	 
Comment: INSPECT WORK TO CURRENT STEP <i>S 09/04/28 (4X)</i>	
3.0	POWDER COATING POWDER COATING
	 <i>m109996</i> 
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 START TIME: <i>15:40</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>16:10</i> <i>cmo/fk</i> <i>09/04/28</i> (4)	
4.0	QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION
	 
Comment: INSPECT POWDER COAT <i>FD 09/04/28</i> (4)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: STEP STRUT

Job Number: 46947

Part Number: D2017131

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST258

SS 09/04/29 (x4)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/30

Job Completion



MF 09-04-29

**Dart Aerospace Ltd**

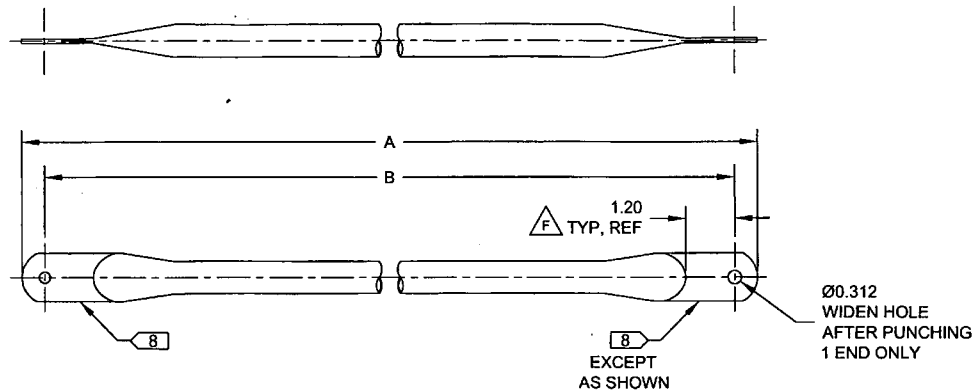
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



### D2017-XXX STEP STRUT

PART NUMBER	A	B
D2017-101	17.73	16.93
D2017-103	18.74	17.94
D2017-113	20.50	19.70

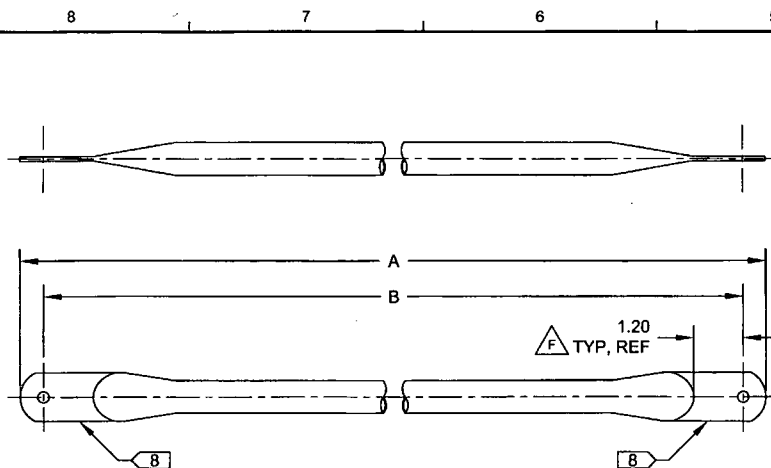
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WITHOUT NOTICE  
WORK ORDER  
NO. 46887

#### NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE,  $\varnothing 0.750 \times 0.049$  WALL.  
REF. DART SPEC M304TR0.750W.049
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2017-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: N/A
- 8) PUNCH ENDS PER SPEC CONTROL DRAWING D2638.

RELEASED  
29/04/16

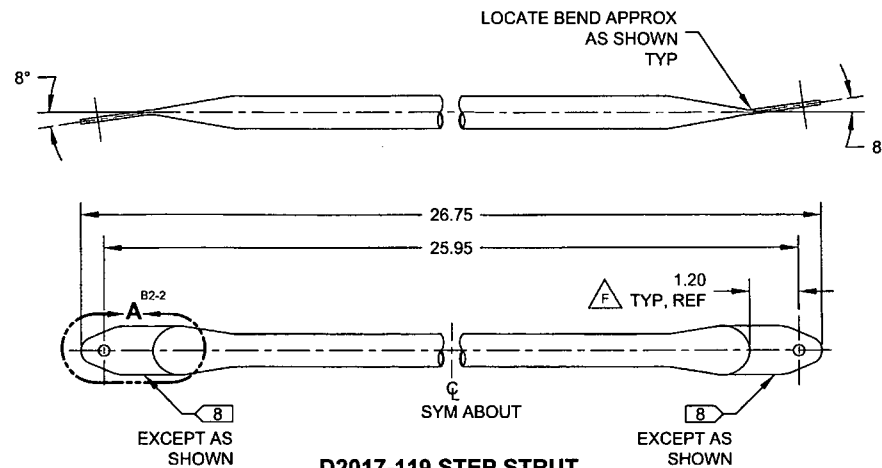
REV.	DESCRIPTION	BY	DATE
F	DRAWING TRANSFERRED TO "B" FORMAT AND TO CURRENT STANDARDS. REDRAWN FOR CLARITY 1.20 REF DIM ADDED. SEE PAR 09-002 FOR DETAILS.	AJS	09.03.06
E	ENDS PUNCHED PER SPEC CTRL; -119 CHANGE (TSR A897) ADD FINISH (INCORPORATE E1)	CP	02.03.22
D	ADDED PARTS	BW	96.03.28
C	ADDED PARTS	BW	95.01.26
DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DATE	09.03.06	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D2017		REV. F	
TITLE STEP STRUTS		SHEET 1 OF 2	
DATE 09.03.06		SCALE NTS	



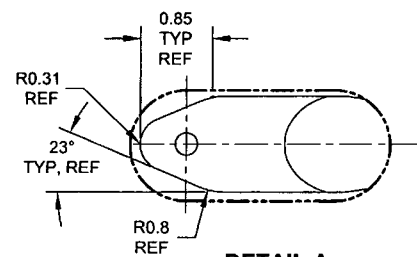
**D2017-XXX STEP STRUT**

PART NUMBER	A	B
D2017-105	14.95	14.15
D2017-107	15.61	14.81
D2017-109	13.93	13.13
D2017-111	15.30	14.50
D2017-115	12.42	11.62
D2017-117	13.86	13.06
D2017-121	12.30	11.50
D2017-123	12.92	12.12
D2017-125	19.55	18.75
D2017-127	20.30	19.50
D2017-129	31.43	30.63
D2017-131	19.68	18.88
D2017-201	21.31	20.51
D2017-203	16.39	15.59
D2017-205	16.53	15.73
D2017-207	13.85	13.05
D2017-209	15.64	15.33
D2017-211	15.67	14.87
D2017-213	15.82	15.02
D2017-215	16.47	15.67
D2017-217	16.70	15.90
D2017-219	13.65	12.85
D2017-221	13.58	12.78
D2017-223	12.95	12.15
D2017-225	13.99	13.19
D2017-227	30.67	29.87
D2017-133	30.66	29.86

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**D2017-119 STEP STRUT**  
 (SHOWN PRIOR TO BENDING)



**DETAIL A** D4-2  
 TRIM AFTER PUNCHING PER DT8360  
 SCALE 2X

**RELEASED**  
 09/04/16

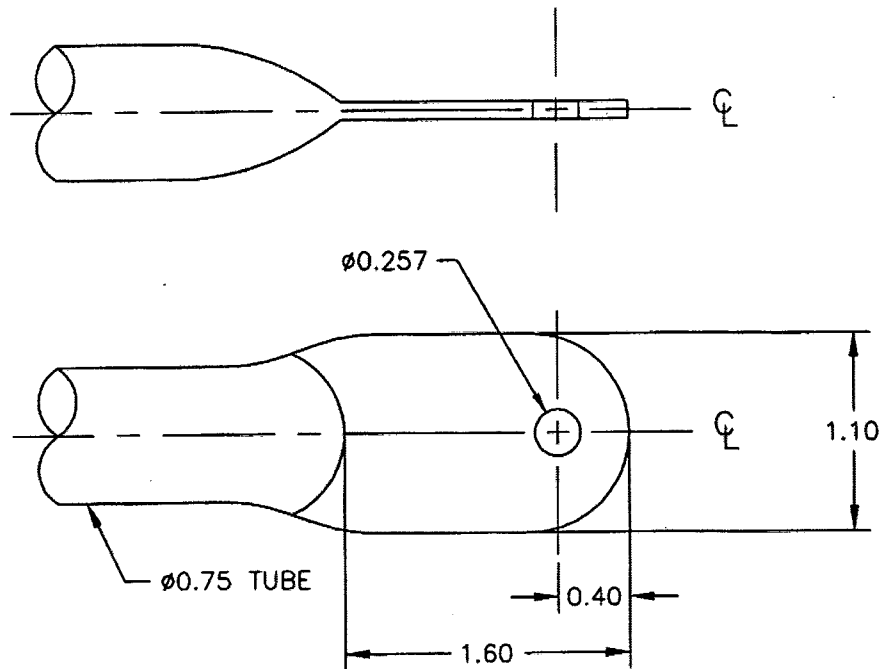
DESIGN	BW	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2017	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP STRUTS	NTS
DATE	09.03.06	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MM	APPROVED KE	DRAWING NO. D2638	REV. A SHEET 1 OF 1
DATE 98.04.28		TITLE PUNCH DT8117 SPEC CONTROL	SCALE 1:1
A	98.04.28	NEW ISSUE	

RELEASED  
98/07/05 KE

SPECIFICATION CONTROL DRAWING  
FOR PUNCH DT8117



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